

(12) **United States Patent**  
**Haymore**

(10) **Patent No.:** **US 9,256,043 B2**  
(45) **Date of Patent:** **Feb. 9, 2016**

(54) **STRENGTH MEMBER SYSTEM FOR FIBER OPTIC CABLE**

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(\*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 447 days.

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(21) Appl. No.: **13/425,007**

(22) Filed: **Mar. 20, 2012**

(65) **Prior Publication Data**

US 2013/0202262 A1 Aug. 8, 2013

**Related U.S. Application Data**

(60) Provisional application No. 61/594,723, filed on Feb. 3, 2012.

(51) **Int. Cl.**  
**G02B 6/44** (2006.01)

(52) **U.S. Cl.**  
CPC ..... **G02B 6/4494** (2013.01); **G02B 6/4413** (2013.01); **G02B 6/443** (2013.01); **G02B 6/4429** (2013.01); **G02B 6/4434** (2013.01)

(58) **Field of Classification Search**  
CPC .... G02B 6/443; G02B 6/4401; G02B 6/4432; G02B 6/4429; G02B 6/4434; G02B 6/4494; G02B 6/4413  
USPC ..... 385/100, 102, 105-107, 109, 110-111  
See application file for complete search history.

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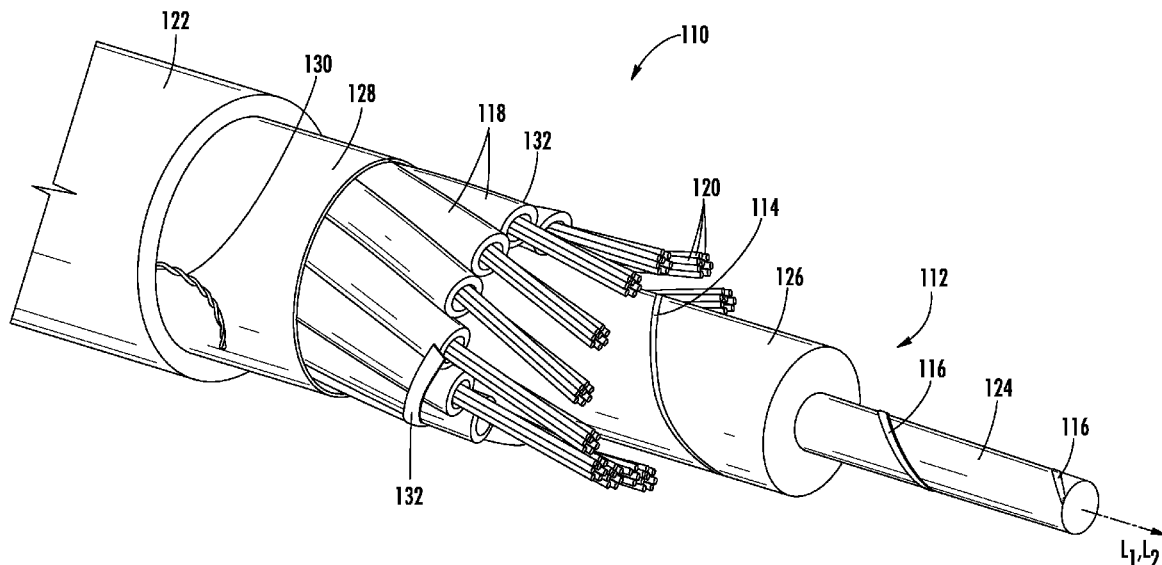
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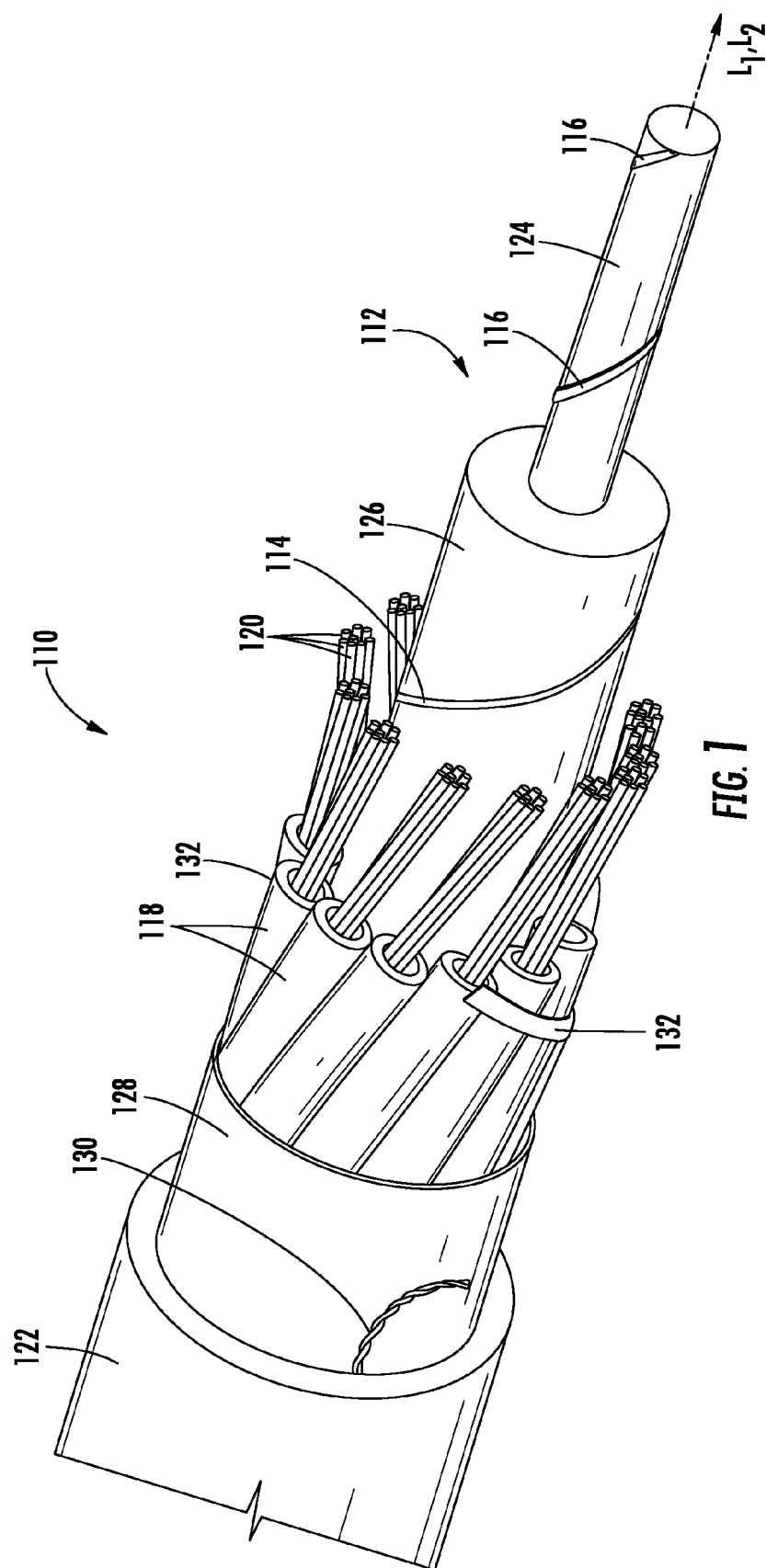
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(57) **ABSTRACT**

A fiber optic cable includes a strength member, a layer of polyethylene contacting the exterior of the strength member, and a yarn wound around the strength member. The yarn is between the strength member and the layer of polyethylene.

**15 Claims, 6 Drawing Sheets**





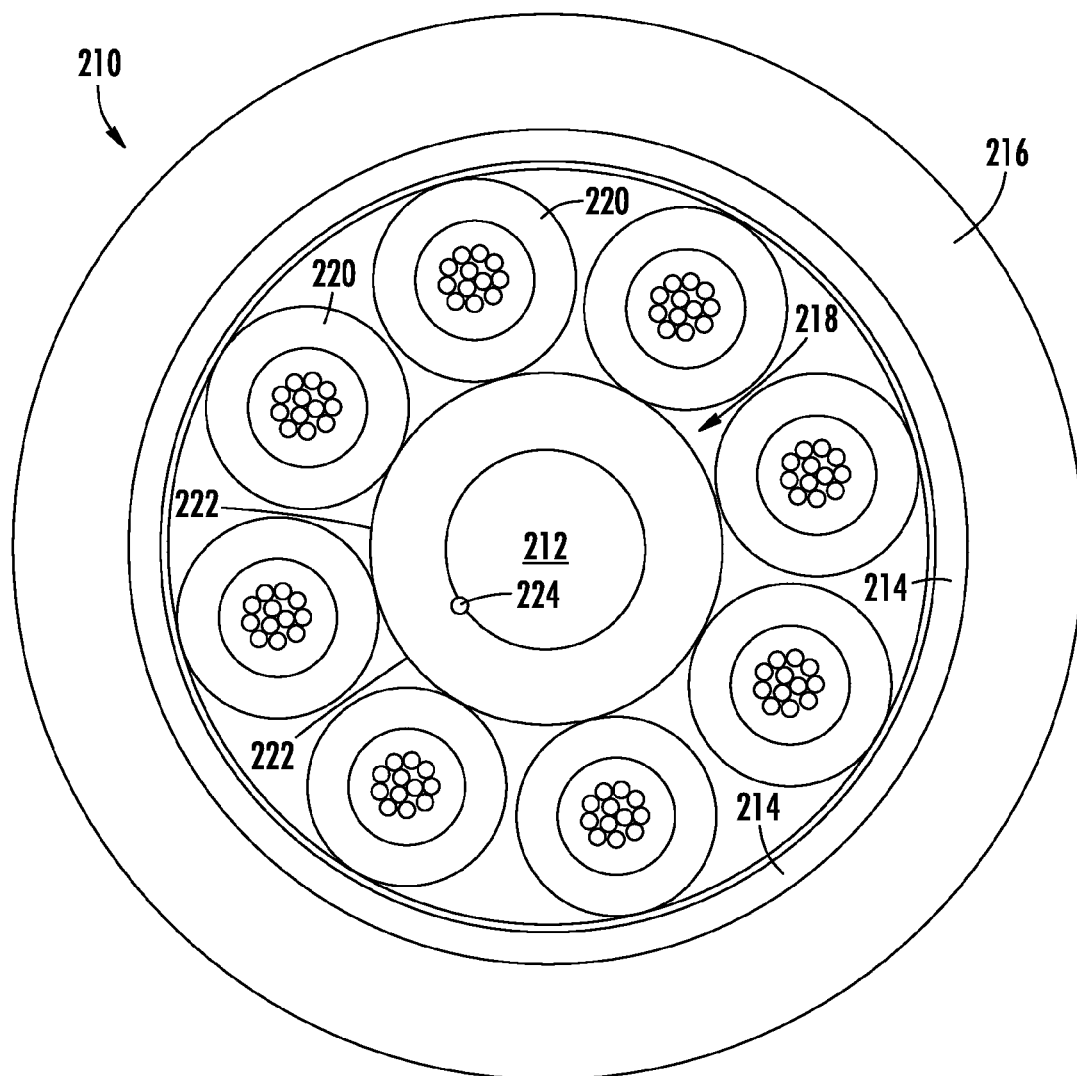


FIG. 2

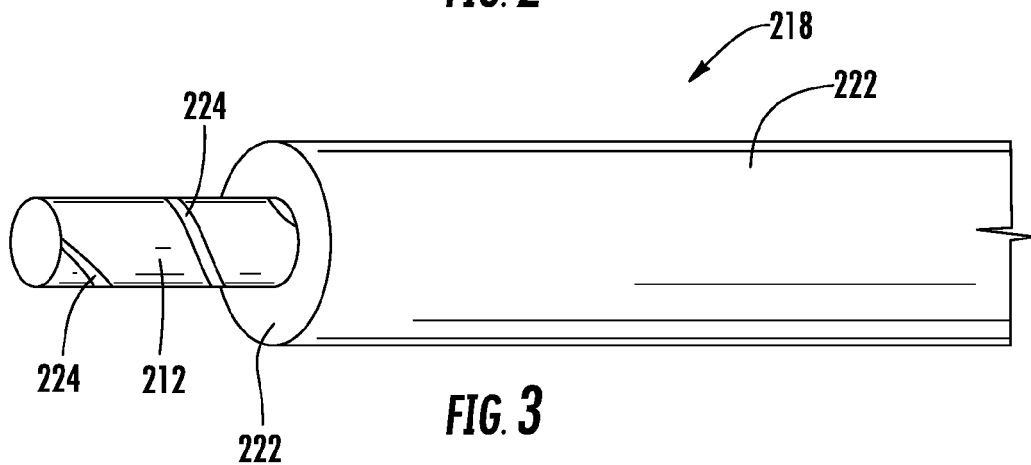
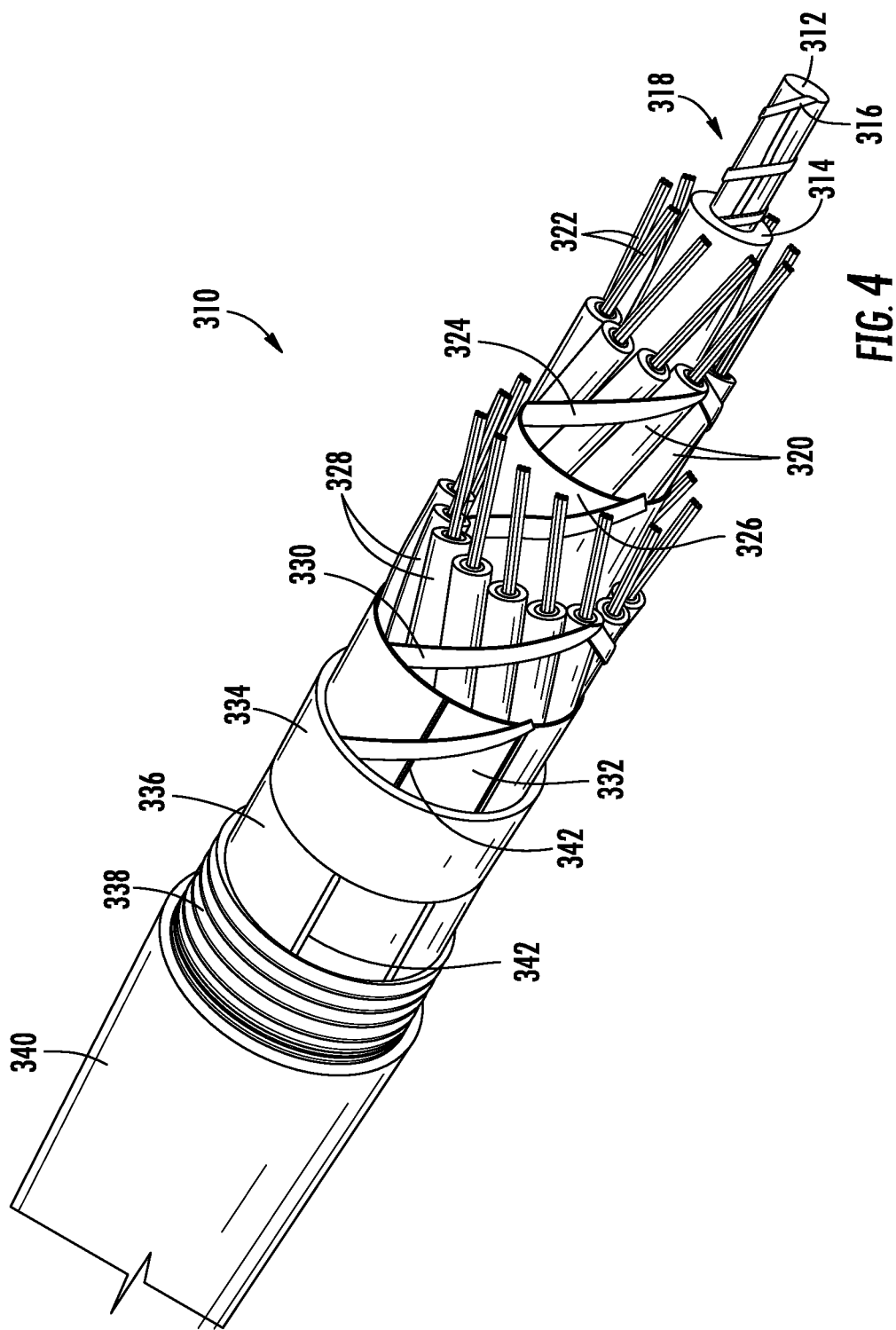
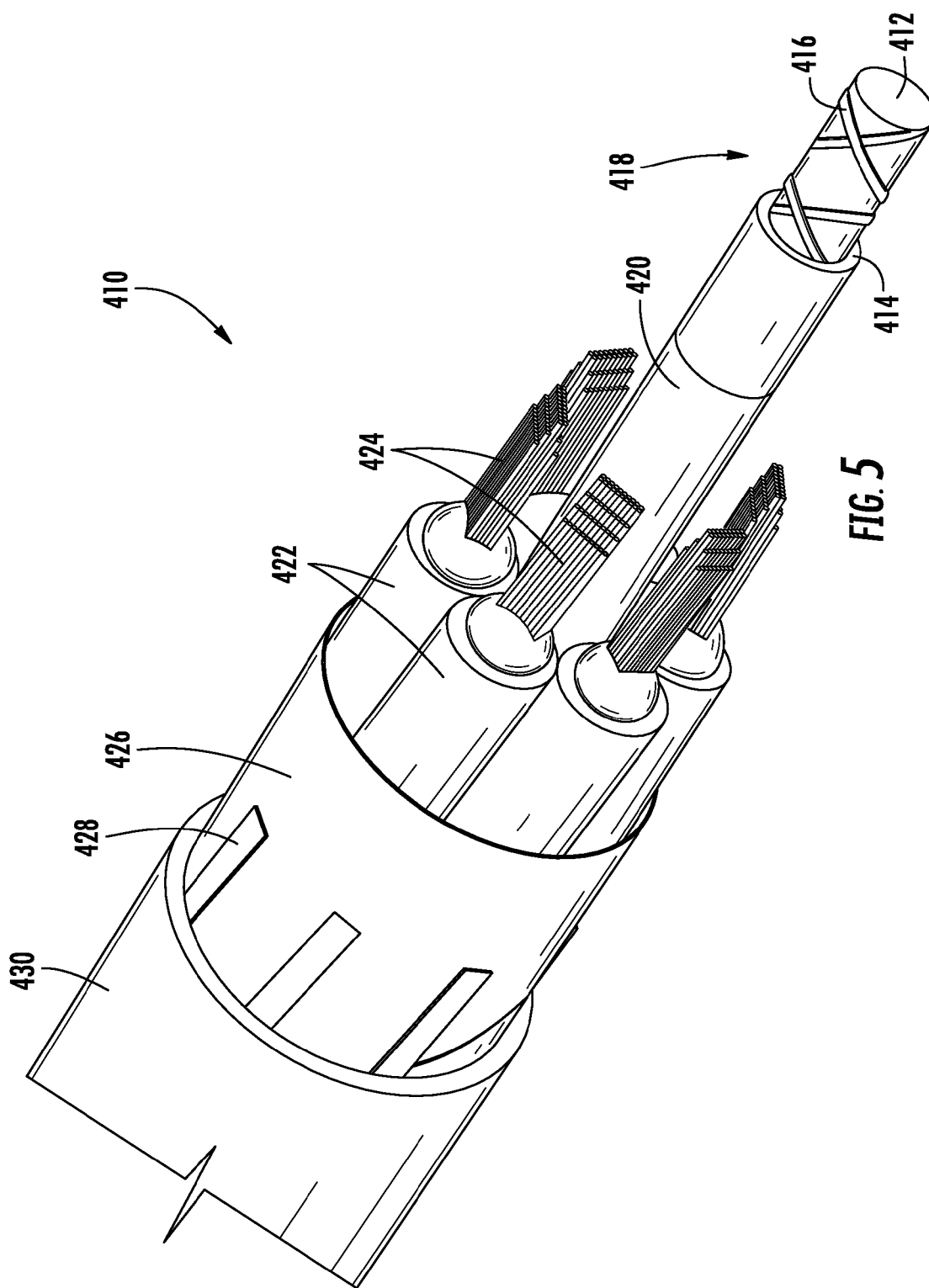
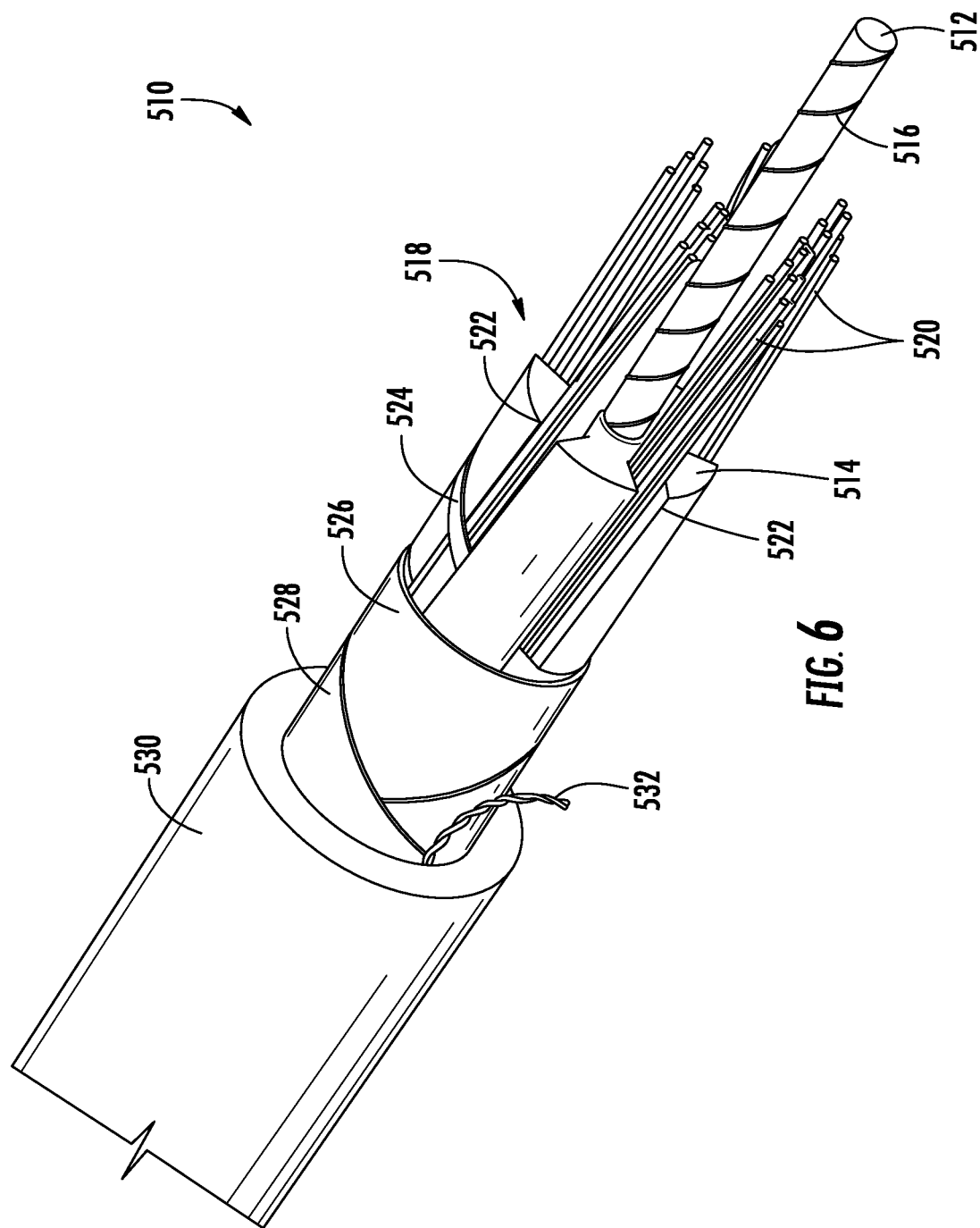
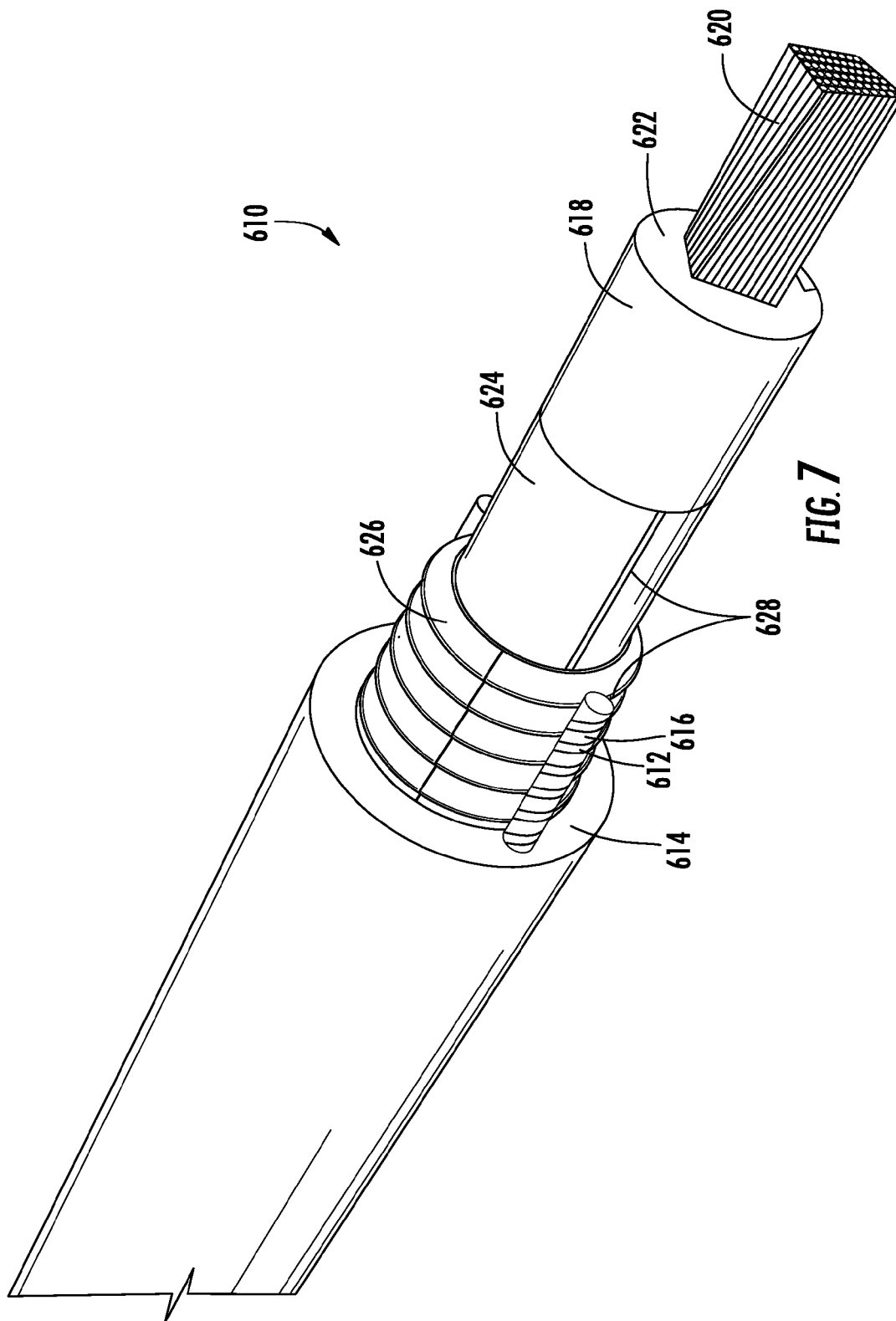


FIG. 3









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# STRENGTH MEMBER SYSTEM FOR FIBER OPTIC CABLE

## PRIORITY CLAIM

This application claims the benefit of priority under 35 U.S.C. §119 of U.S. Provisional Application Ser. No. 61/594,723 filed on Feb. 3, 2012, the entire content of which is relied upon and incorporated herein by reference in its entirety.

## BACKGROUND

The present disclosure relates generally to fiber optic cables, and more specifically to strength member systems of fiber optic cables.

Fiber optic cables typically include strength members, such as glass-reinforced plastic rods that bear stresses experienced by the cables, so as to reduce the transfer of loading to optical fibers carried by the cables. Some loose tube cables include a central guide about which buffer tubes containing optical fibers are stranded (e.g., helically wound). The central guide may include a strength member core with an overcoat or “up-jacket” of additional material that increases the diameter of the central guide so that the buffer tubes have a desired lay length for stranding.

Traditionally, physical bonding and tightness of the overcoat around the strength member core blocks water from penetrating and traveling through the cable between the strength member and the overcoat. Achieving the bond typically relies upon tight extrusion process controls, and in cases of thicker overcoats also may rely upon two or more separate passes down an extrusion line to maintain water-penetration integrity, due to shrinkage of the overcoat material (e.g., up-jacketing compound) causing the overcoat to pull away from the strength member and form a gap through which water may penetrate.

As such, thicker walls for an overcoat are typically extruded in multiple passes to reduce the effects of shrinkage of the overcoat material during cooling, as opposed to a single pass. Furthermore, the overcoat walls may also limit the speed at which the line can run in order to further control the cooling rate. A need exists for a method of sealing an overcoat around a strength member, such as in the central guide of a loose tube fiber optic cable, that allows for a faster line speed and/or single pass down the line, thereby improving manufacturing efficiency.

## SUMMARY

One embodiment relates to a fiber optic cable that includes a strength member, a layer of polyethylene contacting the exterior of the strength member, and a yarn wound around the strength member. The yarn is between the strength member and the layer of polyethylene.

Another embodiment relates to a method of manufacturing a fiber optic cable, which includes a step of winding a yarn about a strength member. The method includes another step of coating the strength member with a layer of polyethylene contacting the exterior of the strength member. The yarn is between the strength member and the layer of polyethylene.

Yet another embodiment relates to a fiber optic cable, which includes a guide. The guide includes a glass-reinforced plastic rod, a first water-swallowable yarn, and a polymer overcoat overlaying the first yarn and the rod. The glass-reinforced plastic rod has a longitudinal axis extending in parallel or co-linearly with a longitudinal axis of the fiber optic cable. The first water-swallowable yarn is helically wound around the

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rod. The fiber optic cable further includes a second water-swallowable yarn helically wound around the exterior of the guide, buffer tubes stranded about the guide and overlaying the second yarn, and a polymer jacket overlaying the buffer tubes. The buffer tubes support optical fibers.

Additional features and advantages will be set forth in the Detailed Description which follows, and in part will be readily apparent to those skilled in the art from the description or recognized by practicing the embodiments as described in the written description and claims hereof, as well as the appended drawings. It is to be understood that both the foregoing general description and the following Detailed Description are merely exemplary, and are intended to provide an overview or framework to understand the nature and character of the claims.

## BRIEF DESCRIPTION OF THE FIGURES

The accompanying drawings are included to provide a further understanding, and are incorporated in and constitute a part of this specification. The drawings illustrate one or more embodiment(s), and together with the Detailed Description serve to explain principles and operation of the various embodiments. As such, the disclosure will become more fully understood from the following Detailed Description, taken in conjunction with the accompanying Figures, in which:

FIG. 1 is a perspective view of a fiber optic cable in a configuration intended to show components of the cable, according to an exemplary embodiment.

FIG. 2 is a sectional view of a fiber optic cable according to an exemplary embodiment.

FIG. 3 is a perspective view of a central guide for a fiber optic cable according to an exemplary embodiment.

FIGS. 4-7 are perspective views of fiber optic cables according to other exemplary embodiments.

## DETAILED DESCRIPTION

Before turning to the figures, which illustrate the exemplary embodiments in detail, it should be understood that the present invention is not limited to the details or methodology set forth in the Detailed Description or illustrated in the Figures. For example, as will be understood by those of ordinary skill in the art, features and attributes associated with embodiments shown in one of the Figures may be applied to embodiments shown in others of the Figures.

A system for blocking water along the interior of a guide formed from a central strength member and an overcoat (e.g., up-jacket) uses a water-swallowable yarn helically wrapped around the strength member, before the up jacketing process. Although a tight overcoat may still be desired, the water blocking ability of the system may not be dependent on the tightness of the bond between the strength member and the overcoat material. If an end of the up jacketed guide is exposed to water, water-swallowable elements in the yarn (e.g., super-absorbent powder (SAP)) will limit or block the passage of water down the interface between the strength member and the overcoat. As such, embodiments disclosed herein allow for an overcoat to be up jacketed to a strength member in fewer passes down a processing line and/or at higher line speeds.

Referring now to FIG. 1, a fiber optic cable in the form of a central-strength-member, loose-tube fiber optic cable includes a guide 112, water-swallowable yarn 114 helically wound around the exterior of the guide 112, buffer tubes 118 stranded around the guide 112 and overlaying the yarn 114, and a polymer jacket 122 overlaying the buffer tubes 118. The



buffer tubes **118** support optical fibers **120**. The guide **112** includes a strength member **124**, another water-swella-  
ble yarn **116**, and a polymer overcoat **126** overlaying the yarn **116**  
and the strength member **124**. In some embodiments, the  
strength member **124** is or includes a glass-reinforced plastic  
(GRP) rod having a longitudinal axis  $L_1$  extending with a  
longitudinal axis  $L_2$  of the fiber optic cable **110**.

According to an exemplary embodiment, the fiber optic  
cable **110** further includes water-swella-  
ble tape **128** between the buffer tubes **118** and the polymer jacket **122**, a rip cord **130**  
between the water-swella-  
ble tape **128** and the polymer jacket **122**, and a binder **132** (e.g., binder yarns) wrapped around the  
buffer tubes **118**. The buffer tubes **118**, the water-swella-  
ble yarns **114**, **116**, and the binder **132** may be helically wound in  
either direction, counter-helically wound forming a crisscross  
pattern, S-Z stranded, or otherwise wound.

Referring to FIG. 2, a fiber optic cable in the form of  
another central-strength-member, loose-tube fiber optic **210**  
cable includes strength elements in the form of a central  
strength member **212** (e.g., main load-bearing member) and  
may also include aramid yarns **214**, fiberglass yarns, or other  
strength elements. According to an exemplary embodiment,  
the fiber optic cable **210** includes water-blocking material,  
such as filling compound, dry swella-  
ble materials (e.g., tape, yarn, etc.), polymers, or other materials. In some embodi-  
ments, the fiber optic cable includes a jacket **216**, which may  
be formed from extruded polyethylene, polyvinyl chloride, or  
other jacketing materials. In some embodiments the jacket  
**216** further includes a nylon or vinyl skin (e.g., outermost  
surface layer). The material of the jacket **216** may include  
additives such as carbon black for UV protection.

Referring to FIGS. 2-3, the fiber optic cable **210** further  
includes a central guide **218** around which buffer tubes **220**  
are stranded. According to an exemplary embodiment, the  
central guide **218** includes the strength member **212** (e.g.,  
load-bearing core), which may be formed from resin bonded  
e-glass (e.g., type of GRP), resin bonded aramid, solid steel,  
stranded steel, or other materials. According to an exemplary  
embodiment, the strength member **212** has an elongate cylin-  
drical body.

According to an exemplary embodiment, the strength  
member **212** has been up jacketed (e.g., over-coated) with an  
overcoat **222**. In some embodiments, the overcoat **222** is  
formed from (e.g., largely consists of, at least 70-percent) a  
polymer material (e.g., up jacketing compound), such as  
polyethylene (e.g., medium or high density polyethylene  
(MDPE, HDPE)). In some embodiments, the overcoat **222** is  
formed from PVC, a low-smoke and fume (LSF) material, or  
another material.

According to an exemplary embodiment, the strength  
member **212** of the central guide **218** includes a yarn **224** (e.g.,  
low-denier water-swella-  
ble yarn) helically wound around the  
strength member **212**, between the strength member **212** and  
the overcoat **222**. The yarn **224** may be drawn from a takeoff  
(e.g., spool) and wound around the strength member **212** by a  
rotating lead, prior to extruding the overcoat **222** over the  
strength member **212**.

According to an exemplary embodiment, the yarn **224** is  
helically wound around the strength member **212**, not placed  
linearly along side of the strength member **212**. In other  
embodiments, yarn may be placed linearly along the strength  
member **212**; or a combination of two yarns may be used,  
where one is helically wound and the other is linearly placed  
(see generally FIG. 4). According to an exemplary embodi-  
ment, the lay length of the yarn **224** is less than 1 meter.

However, the lay length of the yarn **224** around the strength  
member **212** may vary due to yarn package size and pitch  
used to wind the yarn **224**.

In some applications the overcoat **222** may be extruded  
over the strength member **212** at high-speeds down the asso-  
ciated manufacturing line, such as on the order of 60 to 80  
meters per minute. For an overcoat having a thickness of  
about 1.5 to 1.7 mm or more, without use of the yarn **224**, the  
overcoat **222** may be need to be applied to the strength mem-  
ber **212** in two or more passes in order to control the shrinkage  
of the overcoat **222** and avoid a gap between the strength  
member **212** and the overcoat **222**. With the yarn **224**, the  
overcoat **222** may be applied to the strength member **212** in a  
single pass, and any resulting gap between the strength mem-  
ber **212** and the overcoat **222** will be accounted for by the yarn  
**224**.

According to an exemplary embodiment, the yarn **224** is  
500-denier water-swella-  
ble yarn, such as yarns commercially-  
available and produced by FIBER-LINE® and Fil-Tec, Inc.  
However, varying sizes of yarn may be used to apply different  
levels of water-blocking compound into the finished product.  
Additionally, multiple yarns of smaller size may be applied.  
Accordingly, this technology may be used with any combi-  
nation of strength-member size and overcoat wall thickness to  
fill void(s) created therebetween due to up jacketing com-  
pound shrinkage during cooling.

Referring now to FIGS. 4-7, fiber optic cables **310**, **410**,  
**510**, **610** include a strength member **312**, **412**, **512**, **612**, a  
layer of a polymer material **314**, **414**, **514**, **614** (e.g., polyeth-  
ylene) contacting the exterior of the strength member **312**,  
**412**, **512**, **612**, and a yarn **316**, **416**, **516**, **616** (e.g., water-  
swella-  
ble yarn) wound around the strength member **312**, **412**,  
**512**, **612**, between the strength member **312**, **412**, **512**, **612**  
and the respective layer of a polymer material **314**, **414**, **514**,  
**614**, similar to fiber optic cables **110**, **210** shown in FIGS. 1-2.

Referring more specifically to FIG. 4, the fiber optic cable  
**310** includes a central guide member **318** that includes the  
strength member **312**, the overcoat **314**, and the yarn **316**. The  
yarn **316** includes at least two separate pieces, one wound  
helically and the other placed linearly along the strength  
member **312**. Intersections of the pieces of yarn **316** may seal  
off areas of a void or gap between the strength member **312**  
and the overcoat **314**.

According to an exemplary embodiment, in addition to the  
central guide member **318**, the fiber optic cable **310** includes  
a first layer of buffer tubes **320** wound around the guide  
member **318**. Each buffer tube **320** includes a 12-fiber bundle  
**322** of optical fibers and is filled with gel. A binder yarn **324**  
is wound around the first layer of buffer tubes **320** so that the  
buffer tubes **320** may be S-Z stranded about the guide mem-  
ber **318**. Water-swella-  
ble tape **326** is positioned around the  
first layer of buffer tubes **320** and the binder yarn **324**. A  
second layer of buffer tubes **328** is wound around the water-  
swella-  
ble tape **326**, with another binder **330** holding the sec-  
ond layer of buffer tubes **328**. Water-swella-  
ble tape **332** is  
wrapped around the second layer of buffer tubes **328** and  
binder **330** and is itself over-coated with an inner jacket **334**,  
such as a polyethylene jacket. More water-swella-  
ble tape **336**  
and corrugated steel tape armor **338** is positioned over the  
inner jacket **334** and an outer jacket **340** is extruded over the  
armor **338**. Rip cords **342** may be placed between the water-  
swella-  
ble tape **332** and the inner jacket **334** and between the  
water-swella-  
ble tape **332** and the armor **338**.

Referring to FIG. 5, the fiber optic cable **410** includes a  
central guide member **418** that includes the strength member  
**412**, the overcoat **414**, and the yarn **416**. The yarn **416**  
includes at least two separate pieces that are counter-helically

wound with respect to one another forming a crisscross pattern on the exterior surface of the strength member **412**, between the strength member **412** and the overcoat **414**. The intersections of the pieces of yarn **416** may seal off areas of a void or gap between the strength member **412** and the overcoat **414**.

According to an exemplary embodiment, the fiber optic cable **410** further includes water swellable tape **420** wrapped around the exterior of the central guide member **418**. Buffer tubes **422** filled with stacks of fiber optic ribbons **424** (e.g., 6-by-12 ribbon fiber stacks) are stranded around the central guide member **418**. Additional water-swella-  
ble tape **426** is wrapped around the exterior of the layer of buffer tubes **422**. Peripheral strength members **428** (e.g., aramid strips) are positioned around the water-swella-  
ble tape **426**, and the contents of the fiber optic cable **410** are jacketed with a layer **430** of polymer material, such as polyethylene.

Referring to FIG. 6, the fiber optic cable **510** includes a central guide member **518** (e.g., helically-slotted core) that includes the strength member **512**, the overcoat **514** in the form of a helically-slotted overcoat, and the yarn **516**. In some embodiments, the strength member **512** is a steel strength member (e.g., solid steel or stranded). In other embodiments, the strength member **512** is a GRP rod. In some embodiments the helically-slotted overcoat **514** is formed from a polyolefin material.

According to an exemplary embodiment, stacks of fiber ribbons **520** (e.g., 5-by-4 fiber ribbons) are positioned in slots **522** of the helically-slotted overcoat **514**. A binder **524** is placed around the exterior of the helically-slotted overcoat **514** to hold the stacks of fiber ribbons **520** in place. Water-swella-  
ble tape **526** is wrapped around the helically-slotted overcoat **514** and binder **524**. An additional binder **528** is wrapped around the water-swella-  
ble tape **526**. A jacket **530** is extruded over the water-swella-  
ble tape **526** with a rip cord **532** positioned between the water-swella-  
ble tape **526** and the jacket **530**.

Referring to FIG. 7, the fiber optic cable **610** is in the form of a central-tube ribbon cable. The strength member **612**, the overcoat **614** in the form of a jacket for the fiber optic cable **610**, and the yarn **616** are positioned to the side of a center tube **618** (e.g., buffer tube). The center tube **618** is filled with a stack of ribbons **620**, such as 12-fiber ribbons. Filling gel **622** seals the stack of ribbons **620** in the center tube **618**. Water swellable tape **624** is wrapped around the exterior of the center tube **618** and corrugated armor **626** is positioned around the tape **624**. The overcoat **614**, in the form of the jacket, is extruded over the armor **626** as well as the strength member **612** and yarn **616**. Rip cords **628** are placed between the water-swella-  
ble tape **624** and the armor **626**, and between the armor **626** and the overcoat **614**.

In other contemplated embodiments, water-swell compound may also be placed between the strength member and upjacketing compound in the form of water-blocking tapes and other types of yarns and threads as the carrier medium. Loose particles of water-swell compound may also be blown into the area between strength member and overcoat during extrusion, as disclosed in U.S. Pat. Nos. 7,630,605 and 7,983,989 and U.S. application Ser. No. 13/020,174 filed Feb. 3, 2011, each of which is incorporated herein by reference as though fully set forth in its entirety. In some embodiments, water-swell compound may also be applied to the surface of a GRP strength member during manufacturing of the GRP.

Some technology disclosed herein is intended to solve problems associated with applying polyethylene compound around a glass-reinforced plastic rod, such as the subsequent shrinkage of the polyethylene due to cooling that may result

in water-penetration failures of the combined structure. Furthermore, technology disclosed herein may allow for efficiency gains and cost savings due to reduced manufacturing time going from a multiple-pass solution to a single-pass solution. Technology disclosed herein may also allow for line speed increases as well as enhanced water-blocking robustness relative to current methods.

The construction and arrangements of the strength member system for fiber optic cable, as shown in the various exemplary embodiments, are illustrative only. Although only a few embodiments have been described in detail in this disclosure, many modifications are possible (e.g., variations in sizes, dimensions, structures, shapes, and proportions of the various elements, values of parameters, mounting arrangements, use of materials, colors, orientations, etc.) without materially departing from the novel teachings and advantages of the subject matter described herein. For example, other types of optical fiber cable may benefit from the technology disclosed herein, such as drop cable, low-smoke zero-halogen plenum/riser cable, and other types of cable and cable assemblies. Some elements shown as integrally formed may be constructed of multiple parts or elements, the position of elements may be reversed or otherwise varied, and the nature or number of discrete elements or positions may be altered or varied. The order or sequence of any process, logical algorithm, or method steps may be varied or re-sequenced according to alternative embodiments. Other substitutions, modifications, changes and omissions may also be made in the design, operating conditions and arrangement of the various exemplary embodiments without departing from the scope of the present invention.

What is claimed is:

1. A fiber optic cable, comprising:

- a central strength member coaxially located within the fiber optic cable;
- a layer of polyethylene contacting the exterior of the strength member;
- a water-swella-  
ble yarn wound around the strength member,  
between the strength member and the layer of polyeth-  
ylene; and
- buffer tubes supporting optical fibers,  
wherein the layer of polyethylene is an overcoat com-  
pletely surrounding both the central strength member  
and the yarn in the circumferential direction such that  
together the central strength member and the overcoat  
form a guide over which the buffer tubes are stranded.

2. The fiber optic cable of claim 1, wherein strength member is a glass-reinforced plastic rod having a longitudinal axis extending in parallel or co-linearly with a longitudinal axis of the fiber optic cable.

3. The fiber optic cable of claim 2, wherein the yarn is helically wound around the strength member.

4. The fiber optic cable of claim 1, wherein the water-swella-  
ble yarn comprises a super-absorbing polymer.

5. The fiber optic cable of claim 1, wherein the yarn between the strength member and the layer of polyethylene consists of a single piece of yarn that is helically wound.

6. A method of manufacturing a fiber optic cable, comprising steps of:

- winding a water-swella-  
ble yarn around a strength member;
- coating the strength member with a layer of polyethylene contacting the exterior of the strength member, wherein the yarn is between the strength member and the layer of polyethylene and the layer of polyethylene is an overcoat completely surrounding both the central strength member and the yarn in the circumferential direction; and

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stranding buffer tubes, which are supporting optical fibers, around a guide formed by the overcoat, the yarn, and the central strength member.

7. The method of claim 6, wherein the step of winding further comprises helically winding the yarn around the strength member. 5

8. The method of claim 7, wherein strength member is a glass-reinforced plastic rod having a longitudinal axis extending in parallel or co-linearly with a longitudinal axis of the fiber optic cable. 10

9. The method of claim 6, wherein the water-swellaable yarn comprises a super-absorbing polymer.

10. The method of claim 6, wherein the strength member is a central strength member coaxially located within the fiber optic cable. 15

11. The method of claim 6, wherein the yarn between the strength member and the layer of polyethylene consists of a single piece of yarn that is helically wound.

12. The method of claim 6, wherein the step of winding further comprises counter-helically winding separate pieces of the yarn around the strength member such that the pieces form a crisscross pattern with respect to one another around the strength member. 20

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13. A fiber optic cable, comprising:

a guide, comprising:

a glass-reinforced plastic rod having a longitudinal axis extending in parallel or co-linearly with a longitudinal axis of the fiber optic cable,

a first water-swellaable yarn helically wound around the rod; and

a polymer overcoat overlaying and completely surrounding both the first yarn and the rod in the circumferential direction;

a second water-swellaable yarn helically wound around the exterior of the guide;

buffer tubes stranded around the guide and overlaying the second yarn, wherein the buffer tubes support optical fibers; and

a polymer jacket overlaying the buffer tubes.

14. The fiber optic cable of claim 13, wherein the polymer of the jacket and the polymer of the overcoat are the same material.

15. The fiber optic cable of claim 14, wherein the polymer of the jacket and the overcoat is polyethylene.

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